

# Work Order ID 124015

**\*124015\***

September-05-14 1:41:53 PM

Page 1

Item ID: D350-636-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-09-05 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2750-041	G

*Handwritten mark*

100 Document Control 0.00

**\*100\***

DC

Doc.Control -USB or Paperwork

DOCUMENT CONTROL

Memo record fwd angle: 89.6° *Da* 0.00

DAS  
GG  
2-53

OCT 29 2014

*Handwritten mark*

Photocopy blue file and type labels per PPP D350-636-011 CHG 007

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Item ID: D350-636-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Stop **\*NS2\***

Start Date: 9/05/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
<b>*110*</b>									
Skidtubes	<b>Memo</b>	0.00							
Skidtubes	1- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side.								
	***ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE***								
	Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details).Drill using drill Jig DT8150 & DT8863A for 2nd side only DT8863B for first side (detail B)								
	4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE.								
	5- Drill only two fwd step holes using DT9616. Ensure proper positioning.								
	6-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".								
	7-Open up holes of Detail A to 0.297" (total of 2 holes per side)								
	8-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004								

DGL 14-9-10

DGL 14-9-11

DGL 14-9-11

DGL 14-9-12

BE 14-09-19

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Item ID: D350-636-011

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\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Stop \*NS2\*

Start Date: 9/05/14 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*  
Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	A/R Aluminum Rod batch: <u>M129399</u>								
	9-Grind welds flush as per Dwg D2750								
120	QC10- Inspect visual per QSI004- ground welds	0.00							
*120*									
QC	Memo	0.00							
Quality Control									DAS 9 9-89
130	QC5- Inspect part completeness to step on W/O	0.00							
*130*									
QC	Memo	0.00							
Quality Control									DAS 9 9-89

① 14-09-18 DAS  
9  
9-89

① 14-09-19 DAS  
9  
9-89

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**Item ID:** D350-636-011**Accept****\*N900040100\*****Setup Start \*NS1\*****Revision ID:****Item Name:** Skidtube LH Aerazur / Apical Cylindrical Compat.**Stop \*NS2\*****Start Date:** 9/05/14 **Start Qty:** 1.00 **\*1\*****Cust Item ID:****Required Date:** 9/05/14 **Req'd Qty:** 1.00 **\*1\*****Customer:****Reference:**

**Approvals:** **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_

**Run Start \*NR1\*****Stop \*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*140*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									

14-9-22

DP 14-9-22

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Item ID: D350-636-011

Accept

**\*N9000040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Stop **\*NS2\***Start Date: 9/05/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

**\*160\***

Skidtubes

Skidtubes

Skidtubes

**Memo**

0.00

1-Open up holes using hole saw of Detail C and ground handling to 0.625"  
(total of 8 holes per side)  
as per dwg D2750.

2-Open up holes using hole saw of Detail B to 0.750" (total of 4 holes per side)  
as per dwg D2750.

3- Open float hole using un-bit to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750  
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required

7-Bond web D2739 in place as per QSI 015, let cure for 12hrs.

A/R Sikaflex-291

batch:

exp. date:

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004  
(welding instructions on sheet 8)

A/R Aluminum Rod

batch:

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

DP 14-9-22

14-9-22

14-9-23

14-9-24

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Item ID: D350-636-011 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.  
 Start Date: 9/05/14 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 9/05/14 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	11-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750			14-9-24					
	12-Deburr holes, ensure tube is free of all scratches before sending to paint.			14-9-25					
170	QC10- Inspect visual per QSI004- ground welds	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									
									DAS 9 9-89
180	QC5- Inspect part completeness to step on W/O	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control	***VERIFY C'BOARD IS GOOD***								
									DAS 9 9-89

① 14-10-01

① 14-10-01

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**\*N900040100\***

Setup Start \*NS1\*

**Item Name:** Skidtube LH Aerazur / Apical Cylindrical Compat.

Stop \*NS2\*

**Start Date:** 9/05/14      **Start Qty:** 1.00      **\*1\***

**Cust Item ID:**

**Required Date:** 9/05/14      **Req'd Qty:** 1.00      **\*1\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

### Operation Description

### Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

<b>Accept</b>	<b>Reject</b>	<b>Reject</b>	<b>Insp.</b>
<b>Qty</b>	<b>Qty</b>	<b>Number</b>	<b>Stamp</b>

190

Pressure Wash per QSI005 4.3

0.00

**\*190\***

**HandFinish**

## Memo

0.00

## Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200

0.00

**\*200\***

## SprayPaint

## Memo

0.00

## Spray Painting

1- PRIME AS PER DWG AND QSI 005 4.2

PRIMER PRC DESOTO 515X349 BATCH: 128975

2- PAINT WHITE AS PER DWG AND QSI 005 4.2

PAINT BATCH: 13053

210

### QC14- Inspect Spray Paint

0.00

**\*210\***

QC

## Memo

0.00

## Quality Control

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Item ID: D350-636-011

Accept

**\*N19000040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Stop

**\*NS2\***

Start Date: 9/05/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

**\*NR1\***

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
<b>*230*</b>									
HandFinish	Memo	0.00							
Hand Finishing	1- Install inserts as per Dwg D2750								
	2-Inspect for Foreign Objects								
	3- Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>11130227</u> EXP DATE: <u>15109</u>								
	4- Assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>11129305</u> <u>RTU 598</u> <u>13612</u> <u>11125</u> <u>492</u> <u>04015106</u>								
	5- Coat all exposed fasteners with "LPS Procyon" batch: <u>11122900</u>								
240	QC5- Inspect part completeness to step on W/O	0.00							
<b>*240*</b>									
QC	Memo	0.00							
Quality Control									

DAS  
38  
9-89

14-10-22



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Item ID: D350-636-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Stop **\*NS2\***

Start Date: 9/05/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
<b>*250*</b>									
Packaging	Memo	0.00				1X	DAS 26 9-89		OCT 29 2014
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
<b>*260*</b>									
QC	Memo	0.00							
Quality Control	*****ensure antiseize is on AN8C21A bolts*****								OCT 29 2014
						DAS 06 9-89			
270		0.00							
<b>*270*</b>									
Packaging	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-011								
						DAS 46 9-89			OCT 30 2014

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**Item ID:** D350-636-011**Accept****\*N900040100\*****Setup Start \*NS1\*****Revision ID:****Item Name:** Skidtube LH Aerazur / Apical Cylindrical Compat.**Stop \*NS2\*****Start Date:** 9/05/14 **Start Qty:** 1.00 **\*1\*****Cust Item ID:****Required Date:** 9/05/14 **Req'd Qty:** 1.00 **\*1\*****Customer:****Reference:**

**Approvals:** **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_

**Run Start \*NR1\*****Stop \*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
<b>*280*</b>									
QC	<b>Memo</b>	0.00							
Quality Control									

14-10-30

# Picklist Print

September-05-14 1:41:56 PM

Page 1

Work Order ID: 124015

**\*124015\***

Parent Item: D350-636-011

**\*D350-636-011\***

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ  
IPP Rev:J 06-03-23 As per Rev D JLM  
IPP Rev:K 06-07.13 As per dsi9343 EC  
IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC  
IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC  
IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec  
IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010  
DD verf:EC IPP Rev:P 10.06.22 revise  
seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH  
DD verf:EC IPP REV:R 13.08.27 PER ECN13-594 DD  
VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3492-1		Manufactured	No			230	Each	121.0000	8	8			

**\*D3492-1\***

Plug

\*\*

Location

Loc Qty

Loc Code

FP001  
111578  
114879  
119646  
120519  
122460

121  
2  
7  
2  
50  
60

B124026

x 8

D3492-3

Manufactured No

230

Each

142.0000

8

8

**\*D3492-3\***

Plug

\*\*

Location

Loc Qty

Loc Code

FP001  
104853  
107331  
112739  
115807  
118977  
123464

142  
24  
1  
1  
6  
10  
100

B124027

x 8

# Picklist Print

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Work Order ID: 124015

**\*124015\***

Parent Item: D350-636-011

**\*D350-636-011\***

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

383.0000

8

8

**\*NAS1611-010\***

O-RING

\*\*

*all 11/10/22*

Location

Loc Qty

Loc Code

FP001

383

m126988

3

m127813

4

m128375

10

m129198

44

m129405

82

m129523

240

*✓ 8*

NAS1149D0863J

Purchased

No

250

Each

795.0000

2

2

**\*NAS1149D0863.J\***

Washer

\*\*

DAS  
28  
9-89

OCT 29 2014

Location

Loc Qty

Loc Code

ST276

595

118078

2

125268

586

125484

7

*2 k*

ST2776

200

125635

200

D2744

Manufactured

No

110

Each

53.0000

1

1

**\*D2744\***

Cap

\*\*

*BEH-09-19*

Location

Loc Qty

Loc Code

LG001

53

113128

52

115440

1

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Shop Packet Print

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Work Order ID: 124015

**\*124015\***

Parent Item: D350-636-011

**\*D350-636-011\***

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured No

110

Each

1.0000

1

1

**\*D2600-3-BENT\***

Extrusion Bent

\*\*

DCL 14-9-10

Location

Loc Qty

Loc Code

LG002

123533

1

119680

1

D2743

Manufactured No

160

Each

192.0000

8

8

**\*D2743\***

Crossbolt Spacer

\*\*

BE 14-09-23

Location

Loc Qty

Loc Code

LG001

192

109799

1

112729

59

119609

58

120481

74

D2739

Manufactured No

160

Each

13.0000

1

1

**\*D2739\***

350 I Beam

\*\*

Location

Loc Qty

Loc Code

LG

10

123536

10

LG002

3

117245

2

117803

1

D3490-3

Manufactured No

160

Each

72.0000

4

4

**\*D3490-3\***

Cross Bolt Spacer

\*\*

BE 14-09-23

Location

Loc Qty

Loc Code

LG

72

122458

22

122751

50

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Shop Packet Print

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Work Order ID: 124015

**\*124015\***

Parent Item: D350-636-011

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Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

100.0000

4

4

**\*D3490-1\***

Cross Bolt Spacer

**\*\***

*88140923*

Location

Loc Qty

Loc Code

LG

85

*122457*

85

LG001

15

112737

1

116358

14

Each

258.0000

38

ALS4-1032-225

AELS8-1032-225

Purchased

No

**\*AI S4-1032-225\***

*X ALS7-1032-225*

Rivnut

**\*\***

*all 10/10/22*

Location

Loc Qty

Loc Code

FG

30

M127028

30

*X 130565*

*X30*

ST267

228

M127028

10

M127092

26

M128179

192

D3793-3

Manufactured No

230

Each

8.0000

1

1

**\*D3793-3\***

Wearplate Aft

**\*\***

*all 10/10/22*

Location

Loc Qty

Loc Code

FP001

1

104212

1

*B123333*

*X1*

FP002

7

120141

7

# Picklist Print

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Work Order ID: 124015

**\*124015\***

Parent Item: D350-636-011

**\*D350-636-011\***

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

73.0000

1

1

**\*AN8C35A\***

Bolt

**\*\***

*ell 10/10/22*

Location

Loc Qty

Loc Code

FG

4

121275

4

FP001

69

m126293

29

m127823

1

m130114

39

*VI*

D3793-1

Manufactured

No

230

Each

11.0000

1

1

**\*D3793-1\***

Wearplate Fwd

**\*\***

*ell 10/10/22*

Location

Loc Qty

Loc Code

FP002

11

*13123366*

112741

2

120212

8

92382

1

*VI*

D3488-041

Manufactured

No

230

Each

7.0000

1

1

**\*D3488-041\***

Blade Fitting LH

**\*\***

*ell 10/10/23*

Location

Loc Qty

Loc Code

FP001

7

*13122534*

116834

6

88255

1

*VI*

# Picklist Print

September-05-14 1:41:57 PM

Page 6

Work Order ID: 124015

**\*124015\***

Parent Item: D350-636-011

**\*D350-636-011\***

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230

Each

11.0000

1

1

**\*D3794-3\***

Gasket Aft

\*\*

*lll 10/10/22*

Location

Loc Qty

Loc Code

FP001

11

*13124948*

111457

8

122529

2

92658

1

*x1*

AN6C44A

Purchased No

230

Each

45.0000

4

4

**\*AN6C44A\***

Bolt

\*\*

*lll 10/10/22*

Location

Loc Qty

Loc Code

FG

2

103964

2

*M 130665*

*vJ*

ST333

43

m128319

2

m128700

1

m129199

40

MS21083C8

Purchased No

230

Each

64.0000

1

1

**\*MS21083C8\***

Nut

\*\*

*lll 10/10/22*

Location

Loc Qty

Loc Code

ST302

64

m127255

5

m128119

3

m128798

56

*x1*



# Picklist Print

September-05-14 1:41:57 PM

Page 7

Work Order ID: 124015

**\*124015\***

Parent Item: D350-636-011

**\*D350-636-011\***

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3536-25

Manufactured No

230

Each

15.0000

1

1

**\*D3536-25\***

Gasket Center

**\*\***

*all 10/10/22*

Location

Loc Qty

Loc Code

FG

6

B125637

87053

2

95328

4

FP001

9

110652

1

123300

7

93696

1

D3631-1

Manufactured No

230

Each

126.0000

8

8

**\*D3631-1\***

Washer

**\*\***

*all 10/10/22*

Location

Loc Qty

Loc Code

FP001

126

B124353

110258

16

119553

10

123452

100

D3791-1

Manufactured No

230

Each

6.0000

1

1

**\*D3791-1\***

Wearpad

**\*\***

*all 10/10/22*

Location

Loc Qty

Loc Code

FP001

1

B120343

92689

1

FP002

5

118942

5

# Picklist Print

September-05-14 1:41:57 PM

Page 8

Work Order ID: 124015

**\*124015\***

Parent Item: D350-636-011

**\*D350-636-011\***

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

230

Each

3,653.000

38

38

**\*NAS1149C0332R\***

WASHER

**\*\***

*ll 10/10/22*

Location

Loc Qty

Loc Code

CA

83

m129682

83

ST278

3570

122063

41

125654

609

m126319

61

m127306

2500

m127410

75

m127831

26

m128591

75

m129499

183

*✓38*

D2745

Manufactured

No

230

Each

145.0000

8

8

**\*D2745\***

Bushing

**\*\***

*ll 10/10/22*

Location

Loc Qty

Loc Code

ST010

145

107336

4

113176

2

117099

7

119572

51

122643

73

90323

2

93336

6

*✓6*

# Picklist Print

September-05-14 1:41:57 PM

Page 9

Work Order ID: 124015

**\*124015\***

Parent Item: D350-636-011

**\*D350-636-011\***

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased No

230 Each 140.0000 34 34

**\*AN3C5A\***

Bolt

**\*\***

*all 10/1/22*

Location

Loc Qty

Loc Code

FG

5

M130358

*x3.1*

122800

5

ST350

135

M128911

27

M128973

10

M129913

98

D3537-1

Manufactured No

230 Each 93.0000 3 3

**\*D3537-1\***

Wearpad

**\*\***

*all 10/1/22*

Location

Loc Qty

Loc Code

FG

18

79833

8

B124485

*v3*

88562

10

FP001

75

113839

4

120644

52

120645

18

93945

1

NAS1149C0832R

Purchased No

230 Each 258.0000 1 1

**\*NAS1149C0832R\***

Washer

**\*\***

*all 10/1/22*

Location

Loc Qty

Loc Code

ST277

258

m114915

108

m125807

150

*x1*

# Picklist Print

September-05-14 1:41:57 PM

Page 10

Work Order ID: 124015

**\*124015\***

Parent Item: D350-636-011

**\*D350-636-011\***

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased No

230 Each 1,058.000 4 4

**\*AN3C6A\***

Bolt

\*\*

*all 11/10/22*

Location

Loc Qty

Loc Code

FG 10

122416 10

ST513 1048

m125709 52

m128769 996

NAS1611-013

Purchased No

230 Each 140.0000 8 8

**\*NAS1611-013\***

O-RING

\*\*

*all 11/10/22*

Location

Loc Qty

Loc Code

FP001 140

m128375 72

m129430 68

D3535-25

Manufactured No

230 Each 24.0000 1 1

**\*D3535-25\***

Wearplate Center

\*\*

*all 11/10/22*

Location

Loc Qty

Loc Code

FG 2

95077 2

FP002 22

110744 1

123415 20

93278 1

*X*

# Picklist Print

September-05-14 1:41:57 PM

Page 11

Work Order ID: 124015

**\*124015\***

Parent Item: D350-636-011

**\*D350-636-011\***

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3794-1 Manufactured No

230 Each 2.0000 1 1

**\*D3794-1\***

Gasket Fwd

\*\*

all 14/10/22

Location

Loc Qty

Loc Code

FP001

2

B124082

xl

109207

1

93381

1

MS21043-6

Purchased No

230 Each 58.0000 4 4

**\*MS21043-6\***

NUT

\*\*

all 14/10/22

Location

Loc Qty

Loc Code

FG

20

M1130325

xl

103693

20

ST306

38

m127255

6

m127813

32

D3493-1

Manufactured No

250 Each 139.0000 2 2

**\*D3493-1\***

Washer

\*\*

DAS  
26  
9-89

OCT 29 2014

DAS  
03  
3-89

Location

Loc Qty

Loc Code

FG

10

97201

10

ST046

129

109105

129

2x

\*\*\*ONLY INSTALL IF INSTALLING ON APICAL  
FLOAT SYSTEM\*\*\*

# Picklist Print

September-05-14 1:41:57 PM

Page 12

Work Order ID: 124015

**\*124015\***

Parent Item: D350-636-011

**\*D350-636-011\***

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased No

250

Each

64.0000

2

2

**\*MS21083C8\***

Nut

\*\*

m130358

DAS  
26  
9-89

DAS  
66  
9-89

## Location

## Loc Qty

## Loc Code

ST302

64

m127255

5

m128119

3

m128798

56

OCT 29 2014

AN8C21A

Purchased No

250

Each

62.0000

2

2

**\*AN8C21A\***

Bolt

\*\*

DAS  
26  
9-89

OCT 29 2014

DAS  
66  
9-89

## Location

## Loc Qty

## Loc Code

FG

2

123966

2

ST332

60

m127061

2

m127823

3

m129888

55

2x

NAS1515H3L

Purchased No

230

Each

293.0000

4

4

**\*NAS1515H3I \***

Washer

\*\*

1410122

## Location

## Loc Qty

## Loc Code

FG

40

102472

40

ST273

253

m127831

136

m128976

117

x4

# Picklist Print

September-05-14 1:41:57 PM

Page 13

Work Order ID: 124015

**\*124015\***

Parent Item: D350-636-011

**\*D350-636-011\***

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D2741

Manufactured No

250

Each

48.0000

1

1

**\*D2741\***

Blade

**\*\***

DAS  
06  
9-89

Location

Loc Qty

Loc Code

FG

10

100664

5

113640

2

115522

3

ST538

38

118387

38

D3532-1

Manufactured No

250

Each

34.0000

2

2

**\*D3532-1\***

Spacer

**\*\***

DAS  
26  
9-89

OCT 29 2014

DAS  
06  
9-89

Location

Loc Qty

Loc Code

ST048

34

115855

3

117198

3

122723

21

123513

7

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALST-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

#### GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2  
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER  
NO. J24015 M19  
14-09-05

RELEASED  
2013-08-13  
WD

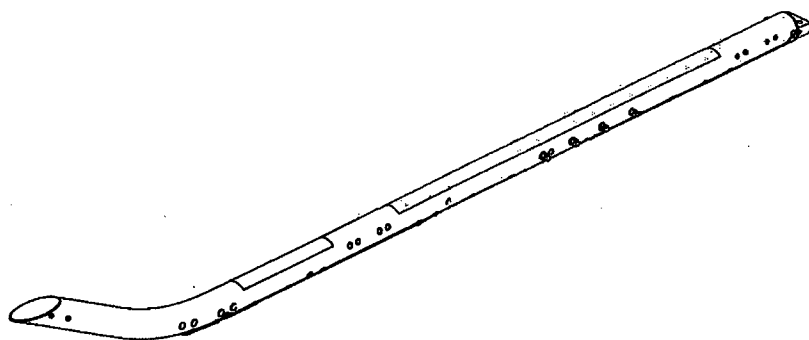
G	CORRECTED TOLERANCE ON Ø0.500 THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-14/-5/-6/-7). UPDATED FINISH OPTIONS: INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413: QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEG 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.11		

DART AEROSPACE USA, INC.  
KENT, WA

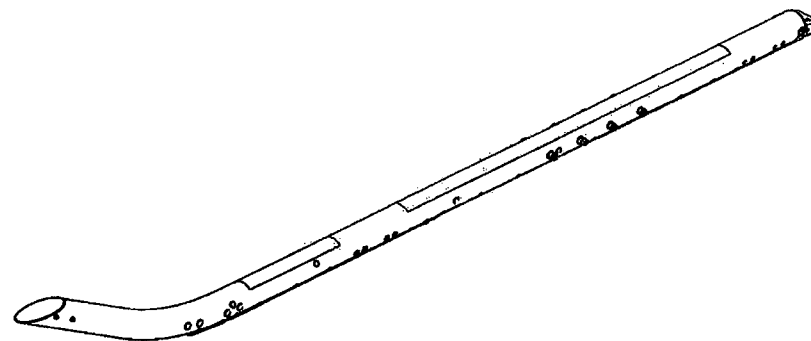
DRAWING NO.  
D2750  
TITLE  
350 SKIDTUBE ASSEMBLY  
REV. G  
SHEET 1 OF 11  
SCALE  
NTS

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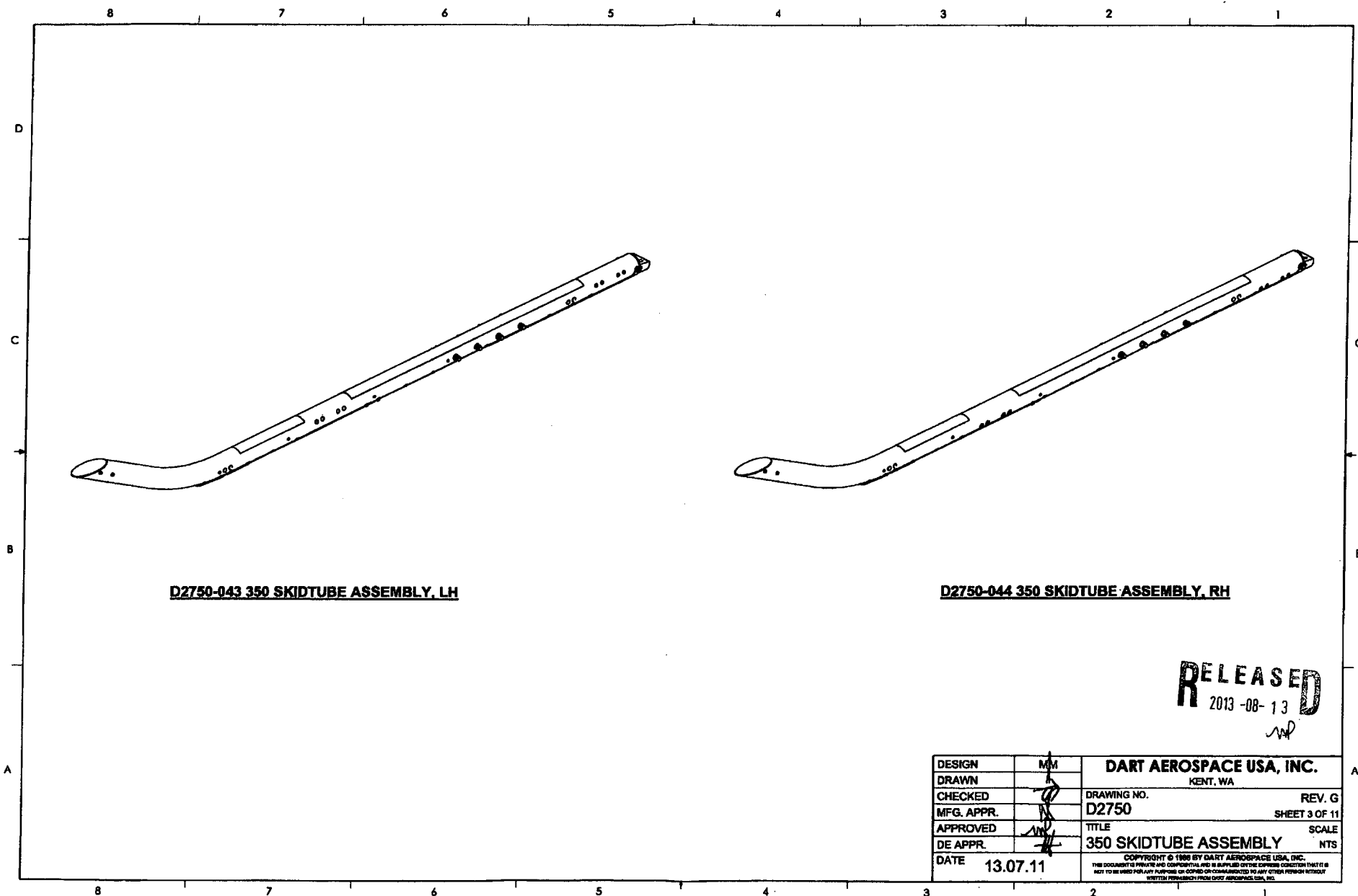
**D2750-041 350 SKIDTUBE ASSEMBLY, LH**



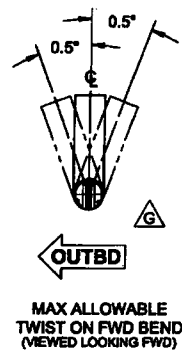
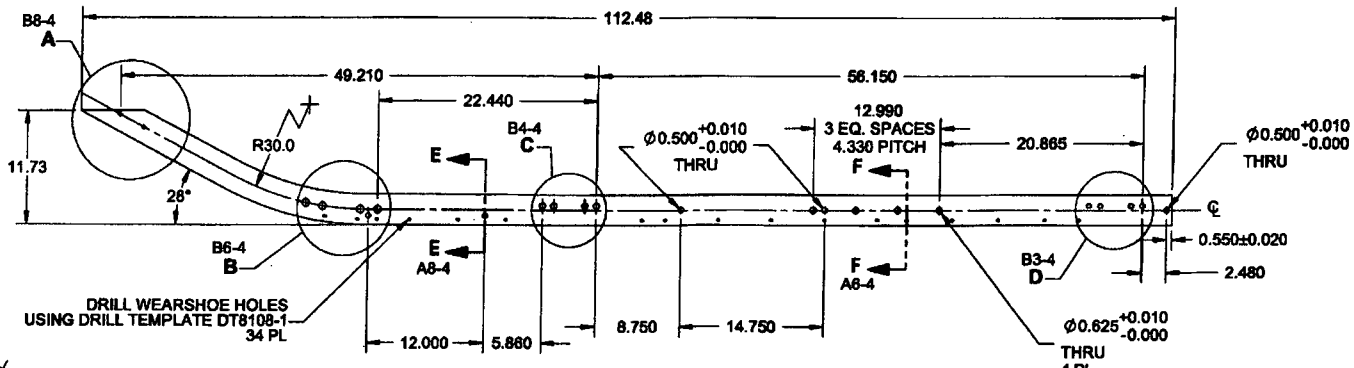
**D2750-042 350 SKIDTUBE ASSEMBLY, RH**

**RELEASED**  
2013-08-13  
MP

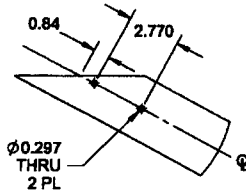
DESIGN	MM	<b>DART AEROSPACE USA, INC.</b>	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 2 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.</small> <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE RELEASED FOR ANY PURPOSE OR FOR ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



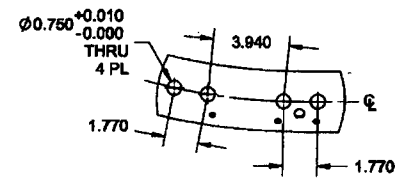
8 7 6 5 4 3 2 1



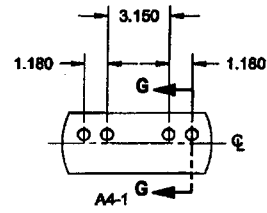
**D2750-1 LH SKIDTUBE**



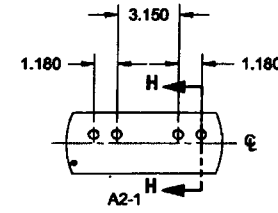
**DETAIL A**  
SCALE 2X



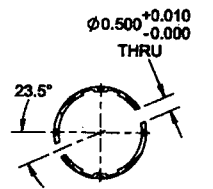
**DETAIL B**  
SCALE 2X



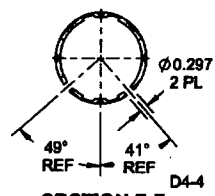
**DETAIL C**  
SCALE 2X



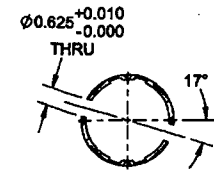
**DETAIL D**  
SCALE 2X



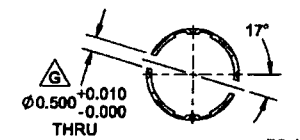
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL

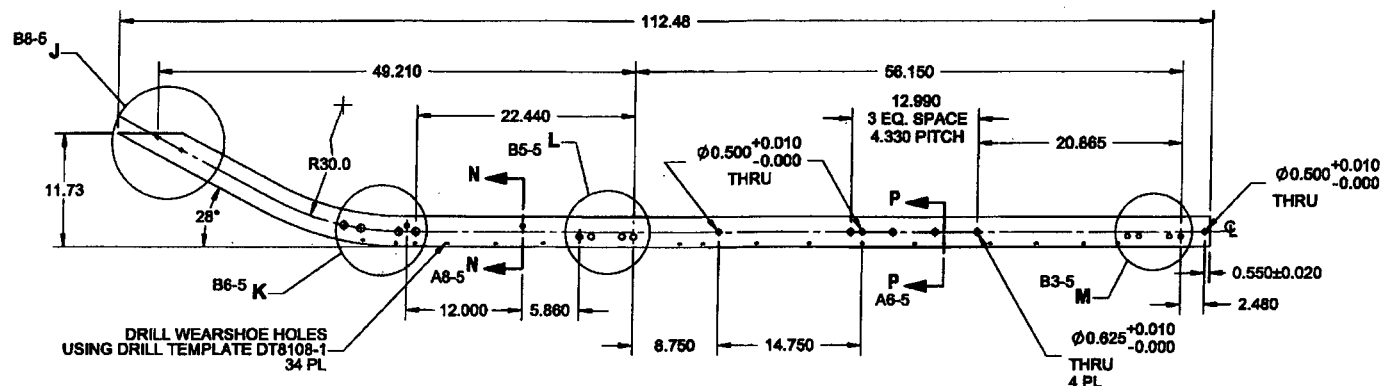


**SECTION H-H**  
SCALE 3X, 4 PL

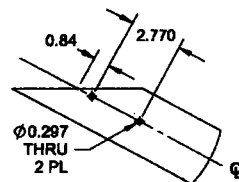
**RELEASED**  
2013-08-13

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DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR CONSIDERED TO BE A SOURCE OF INFORMATION WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

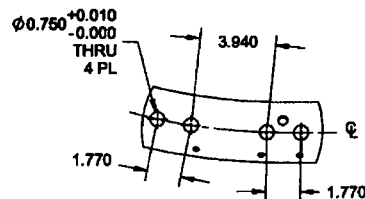
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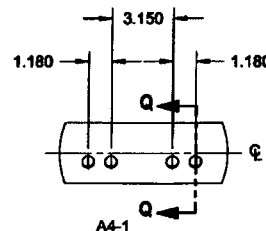
**D2750-2 RH SKIDTUBE**



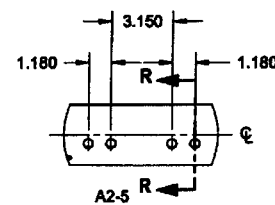
**DETAIL J**  
SCALE 2X



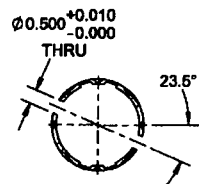
**DETAIL K**  
SCALE 2X



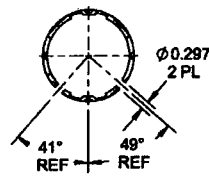
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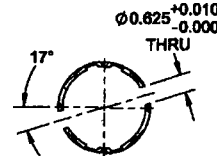
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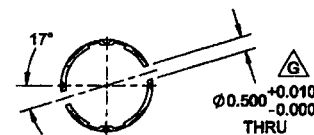
**SECTION N-N**  
SCALE 3X, 2 PL








**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL

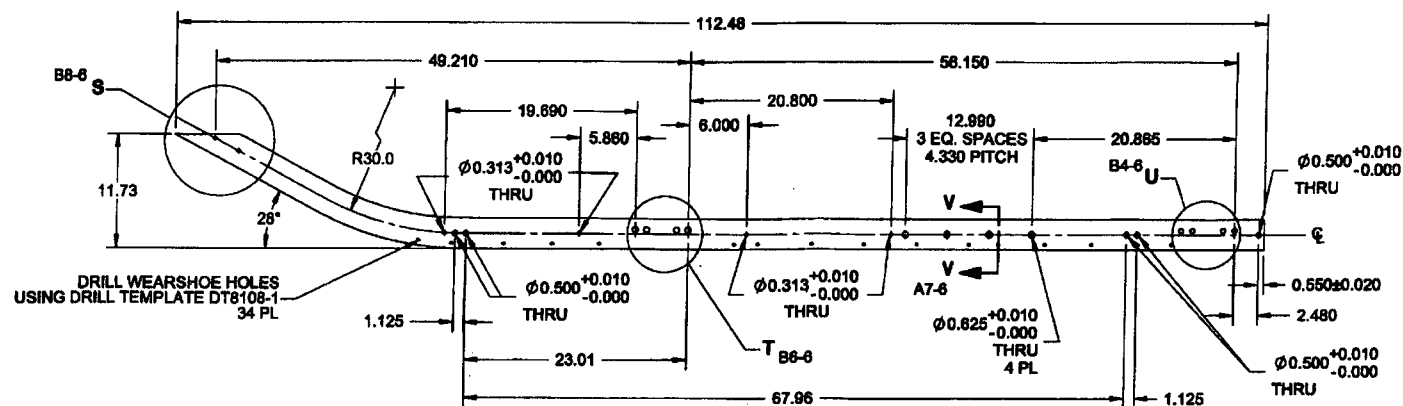


**SECTION R-R**  
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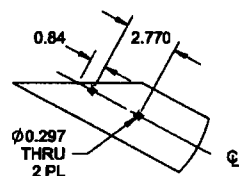
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DE APPR.		DATE <b>13.07.11</b>	
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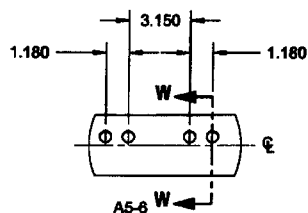
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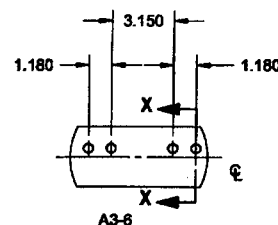
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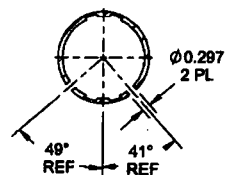
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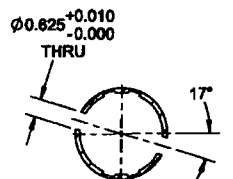
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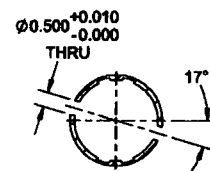
**DETAIL U**  
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**SECTION V-V**  
SCALE 3X, 17 PL



**SECTION W-W**  
SCALE 3X, 4 PL



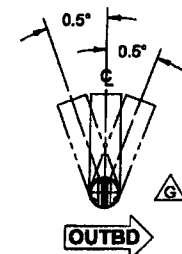
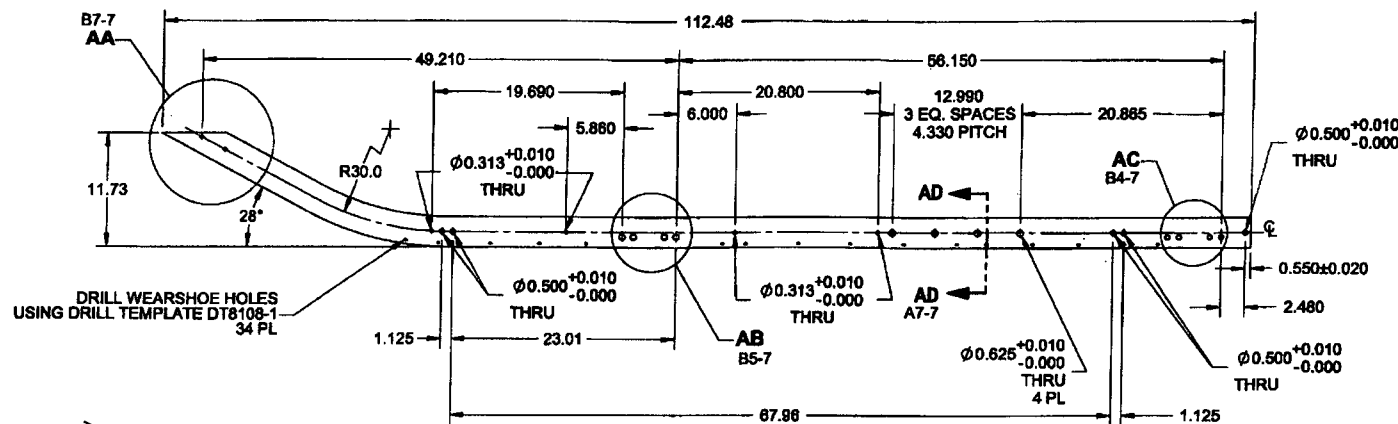
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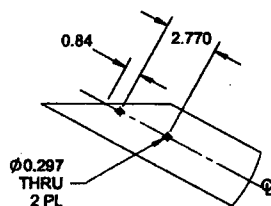
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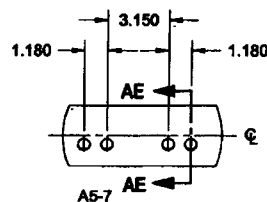
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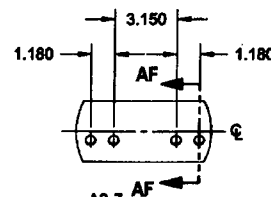
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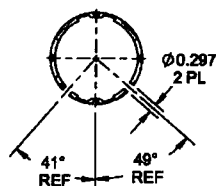
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D7-7  
SCALE 2X



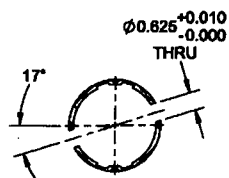
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C4-7  
SCALE 2X



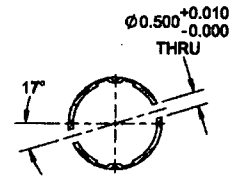
**DETAIL AC**  
D3-7  
SCALE 2X



**SECTION AD-AD**  
D3-7  
SCALE 3X, 17 PL



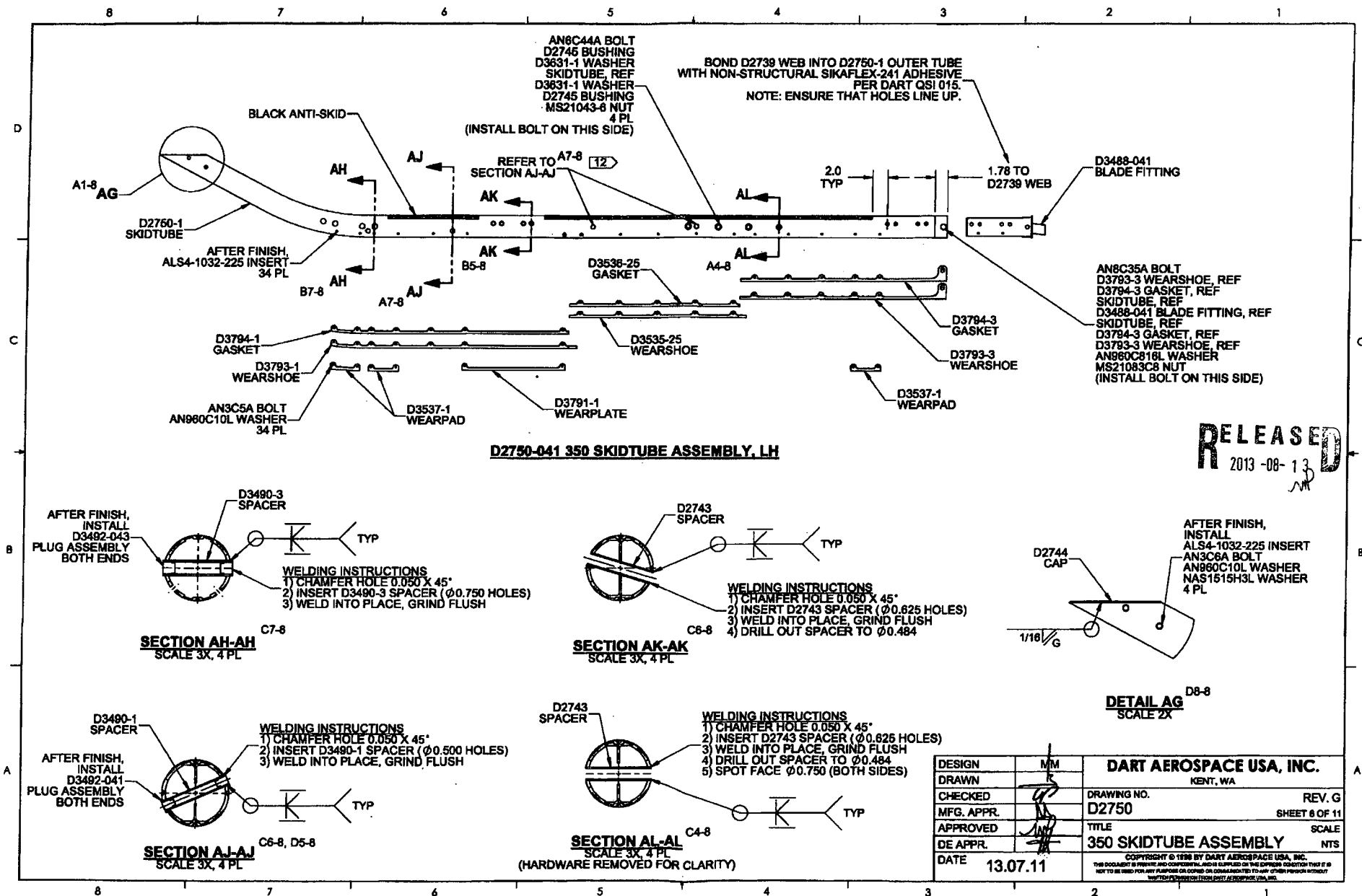
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SCALE 3X, 4 PL



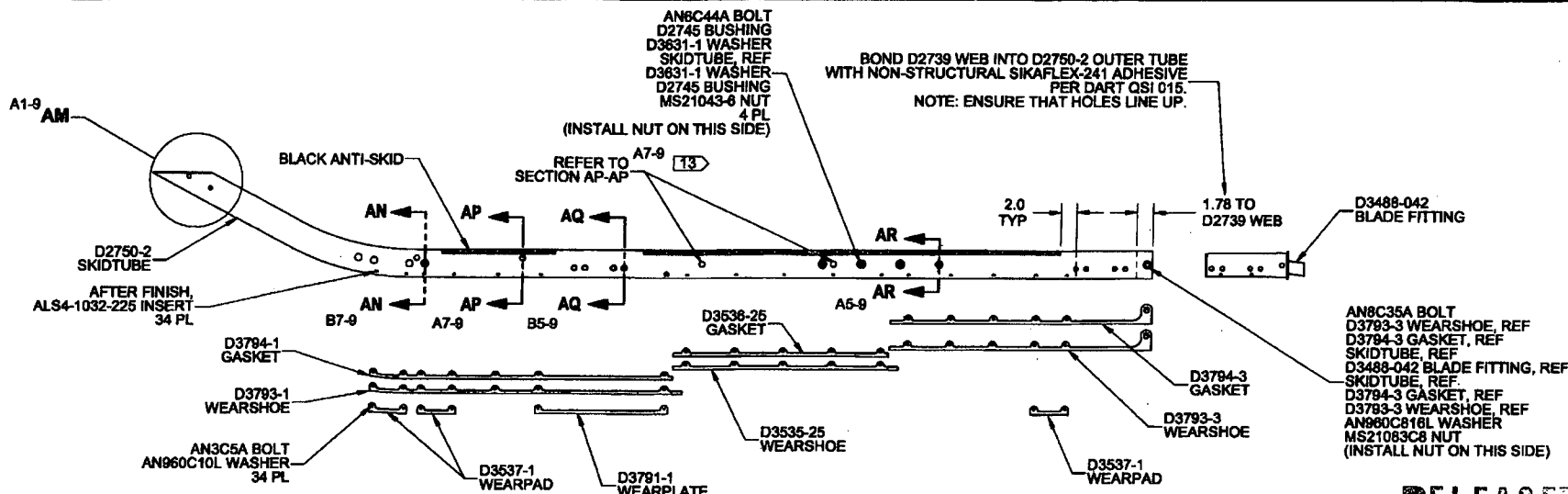
**SECTION AF-AF**  
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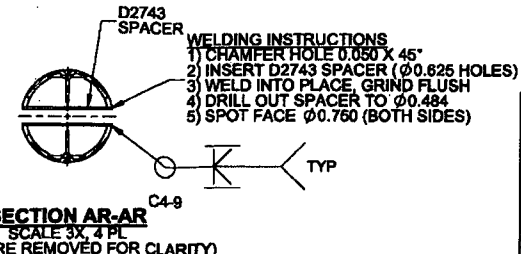
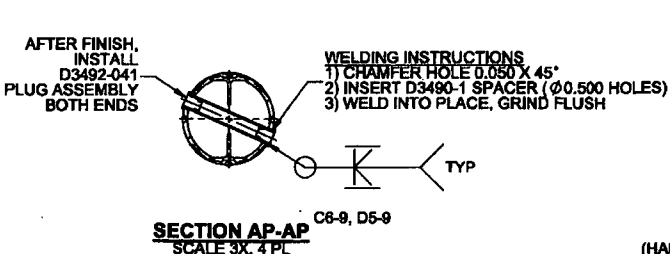
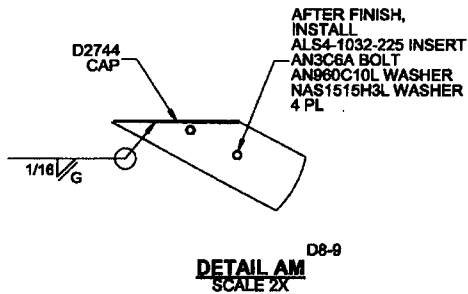
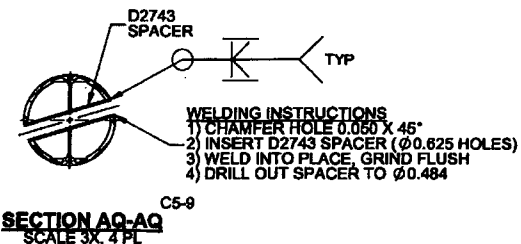
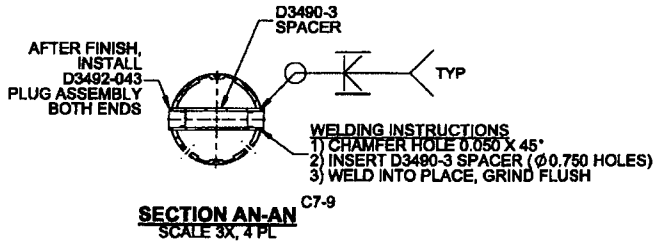


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